	er ID 61696 31, 2010 11:51:50 AM									Page 1
Revision ID:	D3773-3		Accept					Setup Sta Sto		
	Leg 8/31/2010 Start Qty: 9/7/2010 Req'd Qty:	1.48001.400		Cust Item II Customer:) ;	·		510	6	
Approvals:	Process Plan:	Date: D-8-3	Tooling: SPC (Y/N):	Da			1	Run Sta Sto	1 1 33 11121 B	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		1							
D3773	Rev B		1							
100 Doosan Doosan Lathe	1-	emo Turn as per Folio FA763 Rev: 1/4	0.00 0.00 & Dwg D3773 Rev:	Alo □2-Deburr	. / 0 .	8	4			
110 QC Quality Control	QC2- Inspect p	arts off machine FAI/FAIB	0.00	20.10	- 8		4			

0.00

120

Quality Control

QC8- Inspect parts - second check

Memo

12/10/12

Dart Aerospace	Ltd	td	L		е	C	3	à	D	S	0	r	е	4	1	rt	aı	D	
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cateo	orv.	NCR: Yes	No DOA:		Date:	
1 411 140		esolution:							
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCR)		,	
		Description of NC		Corrective Action Section	on B	Verifica	tion	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
					·		<u>.</u> .		

Work Order ID 61696



Page 2

Tuesday, August 31, 2010 11:51:50 AM

Item ID:

Revision ID:

D3773-3

Item Name: Leg

Start Date:

8/31/2010

Start Qty: 4.00 Req'd Qty: 4.00

Required Date: 9/7/2010

Date:_____

Accept

Setup Start

Stop



Cust Item ID:

Customer:

Reference: Approvals:

QC:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Start Run

Stop

Sequence ID/

Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Tool ID

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Dart	Aerospace	Ltd
W/O·		

Dart Aeı	rospace	Ltd							r 9
V/O:			WC	ORK ORDER CHANGES					
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Re	esolution:	Dispositio	n: (A: N/C Clo	sed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMAN	CE (NCR)			
DATE	OTED	Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector
			1						

Picklist Print

Tuesday, August 31, 2010 11:51:55 AM

Work Order ID: 61696

Parent Item: D3773-3

Parent Item Name: Leg

5775-5



Start Date: 8/31/2010

Required Date: 9/7/2010

Page 1

Start Qty: 4.00

Required Qty: 4.00

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IPP Rev:A New Issue 08-07-18 DD Verified By:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prim Item Loca		Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR1.000W.065		Purchased	No	I	110	f	9.7725	1	4.21052	6 ₂	-	
304 PD Tube 1 00 v 065W				1					14	10.1	0.08	*

304 RD Tube 1.00 x .065W

Location

MAT

110010

Loc Qty

9.77247368

1.86 7.91247368

Loc Code

51

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						:			
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Y	es No	DQA:	Date: _	
	Re	esolution:	Disposition	n:	_ QA: N/C	Close	d:	Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (N	CR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section		gn &	Verificatio		Approval
	0.2.	Section A	Chief Eng	Action Description Chief Eng		ate	Section C	Chief Eng	QC Inspector
						li e			
	į								

DART AEROSPACE LTD	Work Order:	41696
Description: Leg	Part Number:	D3773-3
Inspection Dwg: D3773 Rev: B		Page 1 of 1

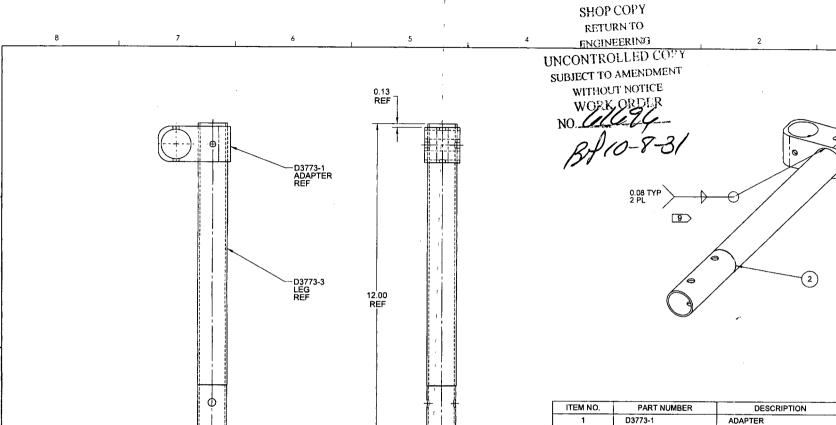
FIRST ARTICLE INSPECTION CHECKLIST

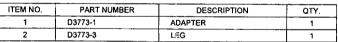
X Fir	st Article	Pı	ototype
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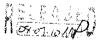
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	nments
	. / 0 020				Пэрсской		<u> </u>
12.00	+/-0.030	12.000					
0.73	+/-0.030	.727					
Ø0.201	+0.005/-0.001	. 204					
R0.03	+/-0.030	103				41.5	
1.70	+/-0.030	1.700					
0.80	+/-0.030	. 800					
3.10	+/-0.030	3.115					
Ø0.257	+0.006/-0.001	,259				1	
Ø0.985	+0.000/-0.010	.983					
Measured by:		Audited by:	1z		Prototype Ap	proval:	N/A
Date: 10 - 8		Date:	0/10/	2		Date:	N/A

Rev	Date	Change		Revised	by	Approved
Α	08.09.04	New Issue		KJ/DD	of the	<i>M</i>
			 -			

	•								
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						*			
Part No		PAR #:							
	Res	solution:	Disposition	1:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Sect Action Description	ion B Sign 8	Verific Secti	cation	Approval Chief Eng	Approval QC inspector
		Section A	Chief Eng	Chief Eng	Date	Secu	On C	Office Eng	QC Inspector







В	CHANG	E HOLE SIZE	TO 0.201	HS	08.06.24
Α	NEWIS	SUE		HS	08.06.04
REV.	1		DESCRIPTION	BY	DATE
DESIG	N	HS	DART AEROSPAC	EL	TD
DRAW	N	HS	HAWKESBURY, ONTARIO,		
CHEC	KED	24	DRAWING NO.		REV. B
MFG. A	APPR.	MIC	D3773		SHEET 1 OF 3
APPRO	OVED	Win	TITLE		SCALE
DE API	PR.	-44	HEADREST ADAPTER		NTS

08.06.24

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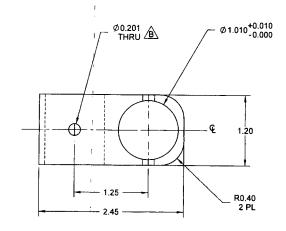
NOTES:
1) MATERIAL: SEE D3773-1/-3
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-3, 0.41, 1.04 lbs
8) WELD: PER DART QSI 004
9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

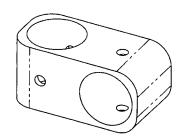
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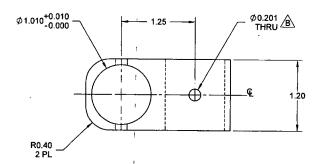
D3773-041 HEADREST ASSEMBLY

Dait Ac	ospace	Lu							¢. *
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	_ Fault Cat	tegory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	_ Disposit	ion:	QA: N/C Clo	sed:		Date: _	
NCR:		W	ORK ORI	DER NON-CONFORMAN	ICE (NCR)			
		Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	1	ion C	Chief Eng	QC Inspector
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D3773-1 ADAPTER



NOTES:	
1) MATERIAL: AISI 304/316 SS BAR (REF D	DART SPEC M304B)
2) FINISH: NONE	, 20,
3) TOLERANCES: PER DART QSI 018 UNL	ESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE IN	
5) BREAK SHARP EDGES: 0.005 TO 0.010	MAX

7

6) IDENTIFICATION: N/A 7) WEIGHT: 0.40 lbs

8

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C

DRAWN HS CHECKED MFG. APPR. APPROVED

DRAWING NO. D3773 TITLE

SHEET 2 OF 3

REV. B

SCALE

DATE 08.06.24

HEADREST ADAPTER

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THE BOOLMERT OF PRIVATE AND CORRESPOND, NO THE PRIVATE ADORSON THE MITTER ADORSON THE PRIVATE ADDRESS ADDRESS AND THE PRIVATE ADDRES NTS

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA

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DESIGN

DE APPR.

HS

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W/O:			W	ORK ORDER CHANG	GES			-		
DATE	STEP	PRO	OCEDURE CHA	NGE	Е	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		,								
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQA	:	_ Date: _	
	Res	olution:	Dispositio	n:	QA: N	C Clo	sed:		Date:	
NCR:		,	WORK ORD	ER NON-CONFORM	IANCE (I	NCR)				
DATE	STEP	Description of NC			ection B		Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section	n C	Chief Eng	QC Inspector
								-		
-								T		
	1		1		j		1			1

2 D 12.00 С R0.03 0.73 0.80 Ø0.985^{+0.000} Ø0.257 THRU 2 PL Ø1.000 REF 0.065 REF Ø0.201 THRU 🖹 3.10 REDUCE TO Ø0.985 **D3773-3 LEG** DESIGN HS DART AEROSPACE LTD NOTES:
1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.69 lbs DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3773 MFG. APPR SHEET 3 OF 3 APPROVED TITLE SCALE HEADREST ADAPTER

NTS

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Dart Aerospace	e Ltd
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W/O:		WORK ORDER CHAN	IGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	, ·	PAR #· Fault Category:	NCR: Yes	No DQ4	١.	Date:	

Part No:P	PAR #: Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
	T	Description of NC		Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC inspector			
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